



Dart Hawkesbury
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Hawkesbury, ON
K6A 1K7
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Tel (613) 632-5200

D5134-041
Job Sheet 165628



Part No: D5134-041

Job Qty: 8 ea

Part Name: Damper Support Assembly, LH



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 9/30/17

Job Tracking No:

Due Date: 10/31/17

Created By: Mario Poulin

Type: Stock

Description:

Note: DWG REV B IPP REV:A NEW ISSUE 14-09-09 JLM VERIFIED BY:DD

Ship Via:

BOM of Materials

Part/Part Name	Part Note	Serial No	Quantity	Location
D5134-041 Damper Support Assembly, LH	DWG REV B IPP REV:A NEW ISSUE 14-09-09 JLM VERIFIED BY:DD		0.000	
M7075T73B3.000X4.000 7075-T73 Bar 3.0 X 4.0 Grain Direction Along 3"			0.000	
NAS77C6-021 Bushing			0.000	

Job Routing

Op No	Operation	Qty	Due Date	Standard		Workcenter/Supplier	
				Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time
90	Start up Operation	8 Ea	10/28/17	0.00	0.00	Start up container	
100	Bandsaw	8 pcs	10/28/17	0.00	0.47	Bandsaw1	
110	CNC Vertical Machining	8 pcs	10/30/17	1.03	18.60	HAAS 1	
120	QC	8 pcs	10/30/17	0.00	0.00	QC2	
130	QC	8 pcs	10/30/17	0.00	0.00	QC8	Me 14-11-13
135	HandFinish	8 pcs	10/30/17	0.00	0.53	HandFinish1	2012-11-13 252
137	QC	8 pcs	10/30/17	0.00	0.00	QC7	AB NOV 20 2017
140	SprayPaint	8 pcs	10/30/17	0.00	2.08	Spray Paint	AB NOV 20 2017
150	QC	8 pcs	10/30/17	0.00	0.00	QC14	33
160	Small Fab	8 pcs	10/31/17	0.00	1.15	Small Fab	PA 11-9-89 33
170	QC	8 pcs	10/31/17	0.00	0.00	QC5	33
180	Packaging	8 pcs	10/31/17	0.00	0.00	Packaging3	AB APR 22 2018
190	QC21-SA	8 Ea	10/31/17	0.00	0.00	QC21	me 18/04/23

Part Op 100 - CUT BLANK TO 5.125" LONG *****CHECK GRAIN DIRECTION*****

Descriptions: 110 - Mill as per Dwg and folio FB342

140 - ***MASK BEARING HOLE AS PER NOTE 2*** PRIME AS PER DWG AND QSI BATCH: 138637 PAINT AS PER DWG AND QSI BATCH: 138637

160 - install bushings as per dwg

180 - LOCATION LG054

Job Allocations

Operation	Component Part	Required	Inventory	Allocated	Std Qty
90-Start up Operation	M7075T73B3.000X4.000	3	0	0	0
160-Small Fab	NAS77C6-021	16	0	0	0

Part Specifications

P.T.O.

NCR:

19-7249

S000856



PART NO: D5134-041

Revision:

Operation: Start up Operation

Quantity: 8

Change No:

Mfg Date: 10/18/17

Job No: 165628

Specifications could not be found.

Plex 10/2/17 2:41 PM Dart.lajeunesse.marie

Work Order ID 165628

Monday, August 28, 2017 11:58:40 AM

165628

Item ID: D5134-041

Accept

Revision ID:

N9000040100

Setup Start

NS1

Item Name: Damper Support Assembly, LH

Stop

NS2

Start Date: 8/16/2017

Cust Item ID:

Required Date: 8/28/2017

Customer:

Reference:

Approvals: Process Plan: 21

Date: AUG 30 2017

Tooling:

Date:

Run

Start

NR1

QC: 9-89

Date: 9-89 SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

D5134

Revision Nbr

B

100

0.00

1000

Bandsaw

Memo

Jeaspa Bandsaw

CUT BLANK TO 5.125" LONG
*****CHECK GRAIN DIRECTION*****

8

2

DAS
1st
9-89 17-10-17

110

1110

HAAS 1

Memo

HAAS CNC vertical machine #1

Mill as per Dwg and folio FB342
DWG REV: 8
FOLIO REV: AA

4.98

8x

2

1000
10/20
2017

DEBURR

DQA: Date: 17-10-18

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: 53 Date: DEC 14 2018Work Order update only ☐

Work Order: <u>165628</u>		DISPOSITION		AGAINST DEPARTMENT/PROCESS											
Part No: <u>DS134-041</u>		Rework ☐ Scrap ☒ Use-as-is ☐		Skid-tube ☐ Machining ☒ Thermoforming ☐ Large Fab ☐		Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐		Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐		Engineering ☐ Quality ☐ Other ☐					
NCR No: <u>18-7042</u>		Suspected Unapproved ☐		QTY Effective: <u>2</u>		Disposition		MRB (QSI042) Approval		DAS <u>12</u> <u>17/10/25</u>					
Date: <u>17/10/18</u>		Step #: <u>110</u>		Description Work Order Deviation		Disposition		DAS completed By: <u>1st</u> <u>9-89</u>		Lead hand / Supervisor Approval <u>38</u> <u>9-89</u>					
<u>1st part</u> - The wrong parameter for the 4axis was used causing the center drill to drill the wrong spot position				<u>Scrap in replace to 138086</u>				QC / QA Coordinator Approval <u>38</u> <u>9-89</u>		OCT 24 2017					
<u>2nd part</u> - The reamer open to $\phi 5012$ - the bushings sizes right in				<u>Scrap in replace to 138252</u>				OCT 24 2017							
Root Cause				FAULT CATEGORY											
Environment ☐				Pressure/Forced ☐				Temperature/Cure ☐				Power Loss/Surge ☐			
Design ☐				No Re-verification ☒				Bending ☐				Folio/Program ☒			
Doc/Data ☐				Operator ☐				Centre Not Concentric ☐				Grain ☐			
Equip/Tooling ☐				Offset/Setup ☐				Cracks ☐				BOM/Route ☐			
Handling/Pre ☐				Supplier ☐				Broken/Damage/Defect ☐				Weld ☐			
Material ☐				Training ☐				Crimp/Kink/Ripple/Wave ☐				Inspection Incomplete/Unqualified ☐			
Internal Transport ☐				Use for Testing ☐				Cuffs ☐				Contamination ☐			
Tribal Knowledge ☐				Poor Information ☐				Crushing ☐				Counter-sink ☐			
LOA ☐				Rushing ☐				Heat Treat ☐				Cut Too Short ☐			
Substation ☐				Product Improvement ☐				Wave/Twist in Tube ☐				Instructions Incomplete/Unclear ☐			
Past Expiry Date ☐				Process Improvement ☐				Marks/Chatter ☐				Drill Holes ☐			
Misidentified ☐				Manufacturing Process ☐				OTHER: ☐				Positioned Wrong ☐			
												☒ Outside Dimensions			
												Over/Under tolerance			
												Part Incorrect			
												Part Lost/Missing			
												Part Moved			
												Drawing			
												Finish			
												Misread			
												Turning Sequence			

Work Order ID 165628

Monday, August 28, 2017 11:58:40 AM

165628

Page 2

Item ID: D5134-041

Accept

Revision ID:

Item Name: Damper Support Assembly, LH

Start Date: 8/16/2017 Start Qty: 8.00

Required Date: 8/28/2017 Req'd Qty: 8.00

Reference:

88

Cust Item ID:
Customer:

N9000040100

Setup Start *NS1*

Stop *NS2*

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

NR1

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120 QC2- Inspect parts off machine FAL/ALB

0.00

120

Memo

0.08

QC

Memo

130

QC8- Inspect parts - second check

0.00

130

QC

Memo

0.16

Quality Control

135

Chemical Conversion Coat per QSI005 4.1

0.00

135

HandFinish

Memo

0.79

Hand Finishing

4x ϕ *see 2017/10/20*

WORK ORDER NON-CONFORMANCE / UPDATE



MD
4 July 2019

DQA: _____ Date: _____

QA Closed: _____ Date: _____

Work Order update only

Work Order: <u>1165628</u> Part No. <u>DS134-041</u> NCR No. <u>19-7249</u>		DISPOSITION Rework ☐ Scrap ☒ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☒ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering Quality ☐ Other ☐		MRB (QS1042) Approval		
Date: <u>16.04.18</u>	Step #: <u>140</u>	QTY Effective: <u>3</u>	Disposition		Completed By 18.04.18			
Description Work Order Deviation bushing in gerd's where pressed in cracked and damage the hole			Scrap destroy qty 3 no replace			Lead hand / Supervisor Approval Verification QC/ QA Coordinator Approval 18.04.18		
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐			FAULT CATEGORY No Re-verification ☐ Operator ☒ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐			Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☒ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		
OTHER :								

Work Order ID 165628

Monday, August 28, 2017 11:58:40 AM

165628

Item ID: D5134-041 Accept *N9000040100* Setup Start *NS1*

Revision ID: Damper Support Assembly, LH Stop *NS2*

Start Date: 8/16/2017 Start Qty: 8.00 Cust Item ID: *NS2*

Required Date: 8/28/2017 Req'd Qty: 8.00 Customer: *NS2*

Reference:

Approvals: Process Plan: Date: Tooling: Date: Run Start *NR1*

QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
137	QC7-Inspect Chemical Conversion Coat	0.00							

127 Memo 0.08

QC Quality Control

140 Spray Painting per QSI005 4.2 0.00

140 Memo 4.96

SprayPaint ***MASK BEARING HOLE AS PER NOTE 2***

Spray Painting PRIME AS PER DWG AND QSI

BATCH: _____

PAINT AS PER DWG AND QSI

BATCH: _____

QC14- Inspect Spray Paint

QC Memo 0.08

150 QC14- Inspect Spray Paint 0.08

150 Memo 0.08

QC Quality Control

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube Machining ☐ Thermoforming Large Fab ☐ Cross tube Small Fab ☐ Finishing Composite ☐ Water Jet Prod. Eng. Coord. ☐ Rec/Store/Packaging Supplier ☐ Engineering Quality Other ☐							
Date: _____	Step #: _____	QTY Effective: _____		MRB (QSI042) Approval							
Description Work Order Deviation		Disposition		Completed By							
				Lead hand / Supervisor Approval Verification							
				QC / QA Coordinator Approval							
Root Cause Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐		FAULT CATEGORY No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐		Pressure/Forced Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐		Temperature/Cure Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐		Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐		Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐	
OTHER: _____											

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐		Engineering ☐ Quality ☐ Other ☐																	
Date: _____		Step #: _____		QTY Effective: _____		MRB (QS1042) Approval																	
Description Work Order Deviation				Disposition																			
				Completed By																			
				Lead hand / Supervisor Approval Verification																			
				QC / QA Coordinator Approval																			
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OTHER: _____																							

Monday, August 28, 2017 11:58:40 AM

165628

Accept

Revision ID:

N9nnn4n1nn

Setup Start

NS

Item Name: Damper Support Assembly, LH

Stop

NS

Start Date: 8/16/2017 **Start Qty:** 8.00

CC*

Cust Item ID:

Required Date: 8/28/2017 **Req'd Qty:** 8.00

✱

Customer:

Reference:

Approvals: **Process Plan:**

Date:

Tooling:

Date:

Run Start

Zr

QC:

Date:

SPC (Y/N):

Date:

Stop

NR

Sequence ID/
Work Center ID

Operation Description

Set Up/
Run Hours

Tool ID	Tool #
---------	--------

[illegible]

Accept
Oty

Reject
Qty

Reject	Insp.
--------	-------

190

QC21- Final Inspection - Work Order Release

0.00

1968

Memo

0.80

Quality Control

DQA: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐																																																																																																																																																					
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<table border="1" style="width: 100%; border-collapse: collapse;"> <thead> <tr> <th colspan="4" style="text-align: left;">Root Cause</th> <th colspan="8" style="text-align: left;">FAULT CATEGORY</th> </tr> </thead> <tbody> <tr> <td>Environment</td><td>☐</td> <td>No Re-verification</td><td>☐</td> <td>Pressure/Forced</td><td>☐</td> <td>Temperature/Cure</td><td>☐</td> <td>Power Loss/Surge</td><td>☐</td> <td>Positioned Wrong</td><td>☐</td> </tr> <tr> <td>Design</td><td>☐</td> <td>Operator</td><td>☐</td> <td>Bending</td><td>☐</td> <td>Set-up</td><td>☐</td> <td>Folio/Program</td><td>☐</td> <td>Outside Dimensions</td><td>☐</td> </tr> <tr> <td>Doc/Data</td><td>☐</td> <td>Offset/Setup</td><td>☐</td> <td>Centre Not Concentric</td><td>☐</td> <td>BOM/Route</td><td>☐</td> <td>Grain</td><td>☐</td> <td>Over/Under tolerance</td><td>☐</td> </tr> <tr> <td>Equip/Tooling</td><td>☐</td> <td>Supplier</td><td>☐</td> <td>Cracks</td><td>☐</td> <td>Broken/Damage/Defect</td><td>☐</td> <td>Weld</td><td>☐</td> <td>Part Incorrect</td><td>☐</td> </tr> <tr> <td>Handling/Pre</td><td>☐</td> <td>Training</td><td>☐</td> <td>Crimp/Kink/Ripple/Wave</td><td>☐</td> <td>Inspection Incomplete/Unqualified</td><td>☐</td> <td>Wrong Stock Pulled</td><td>☐</td> <td>Part Lost/Missing</td><td>☐</td> </tr> <tr> <td>Material</td><td>☐</td> <td>Use for Testing</td><td>☐</td> <td>Cuffs</td><td>☐</td> <td>Contamination</td><td>☐</td> <td>Out of Sequence</td><td>☐</td> <td>Part Moved</td><td>☐</td> </tr> <tr> <td>Internal Transport</td><td>☐</td> <td>Poor Information</td><td>☐</td> <td>Crushing</td><td>☐</td> <td>Countersink</td><td>☐</td> <td>Off-set</td><td>☐</td> <td>Drawing</td><td>☐</td> </tr> <tr> <td>Tribal Knowledge</td><td>☐</td> <td>Rushing</td><td>☐</td> <td>Heat Treat</td><td>☐</td> <td>Cut Too Short</td><td>☐</td> <td>Mislabeled</td><td>☐</td> <td>Finish</td><td>☐</td> </tr> <tr> <td>LOA</td><td>☐</td> <td>Product Improvement</td><td>☐</td> <td>Wave/Twist in Tube</td><td>☐</td> <td>Instructions Incomplete/Unclear</td><td>☐</td> <td>Fit/Function</td><td>☐</td> <td>Misread</td><td>☐</td> </tr> <tr> <td>Substation</td><td>☐</td> <td>Process Improvement</td><td>☐</td> <td>Marks/Chatter</td><td>☐</td> <td>Drill Holes</td><td>☐</td> <td>Misaligned/off center</td><td>☐</td> <td>Turning Sequence</td><td>☐</td> </tr> <tr> <td>Past Expiry Date</td><td>☐</td> <td>Manufacturing Process</td><td>☐</td> <td colspan="8" rowspan="2">OTHER: _____</td> </tr> <tr> <td>Misidentified</td><td>☐</td> <td>Past Due</td><td>☐</td> </tr> </tbody> </table>						Root Cause				FAULT CATEGORY								Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐	Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐	Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐	Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐	Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐	Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐	Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐	Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐	LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐	Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐	Past Expiry Date	☐	Manufacturing Process	☐	OTHER: _____								Misidentified	☐	Past Due	☐
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Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐																																																																																																																																														
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐																																																																																																																																														
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐																																																																																																																																														
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐																																																																																																																																														
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐																																																																																																																																														
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐																																																																																																																																														
Past Expiry Date	☐	Manufacturing Process	☐	OTHER: _____																																																																																																																																																					
Misidentified	☐	Past Due	☐																																																																																																																																																						

Picklist Print

Monday, August 28, 2017 11:58:44 AM

Work Order ID: 165628

Parent Item: D5134-041

Parent Item Name: Damper Support Assembly, LH

165628
D5134-041

Start Date: 8/16/2017

Required Date: 8/28/2017

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP REV:A NEW ISSUE 14-09-09 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M7075T73B3.000X4.00
0
M7075T73B3.000X4.000

DAS
1 K
9-89 17-10-17

Location

Loc Qty

Loc Code

MAT ~~m138252~~ **F0000022**

MAT006 ~~m138252~~

MAT006 m138252

MAT006 m138252 12 12 160 Each 379.0000

3.443 + 0.430 + 0.130 = 3.993
6.443 - 0.430 = 6.013

NAS77C6-021
BUSHING
NAS77C6-021

2
16

Location

Loc Qty

Loc Code

ST554

M134793

M134833

379
129
250

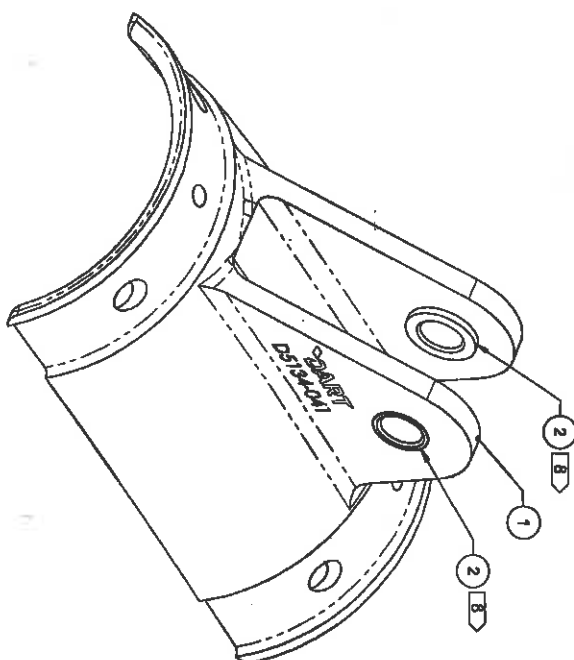
3.443 + 0.430 + 0.130 = 3.993
6.443 - 0.430 = 6.013

AEROSPACE

Work Order update only

Work Order: _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec./Store/Packaging ☐ Supplier ☐ Engineering Quality ☐ Other ☐	
Part No. _____					
NCR No. _____		Step #: _____		QTY Effective : _____	
Date : _____		Description Work Order Deviation		Disposition	
				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	

ITEM	QTY	P/N	DESCRIPTION
1	1	D5134-041	DAMPER BRACKET ASSY, LH
2	2	D5134-1	DAMPER SUPPORT, LH
3	2	NA57708-021	BUSHING



D5134-041 DAMPER SUPPORT ASSY, LH

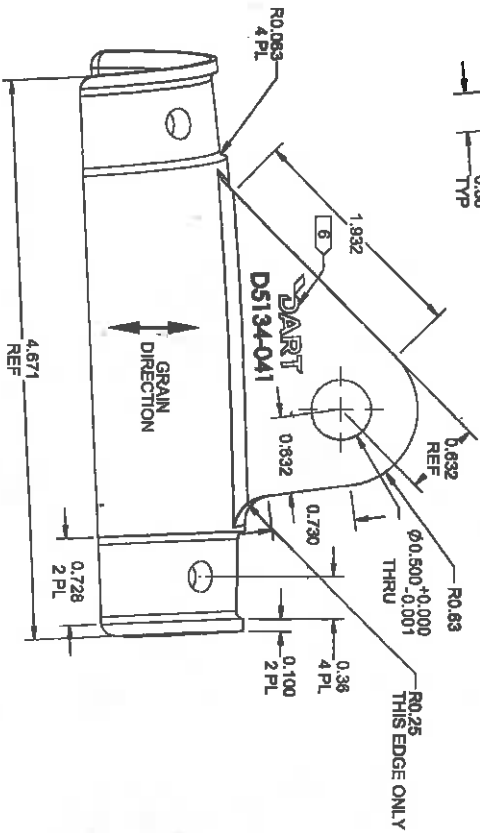
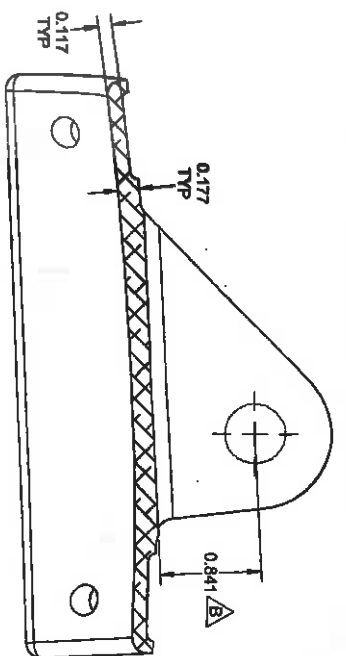
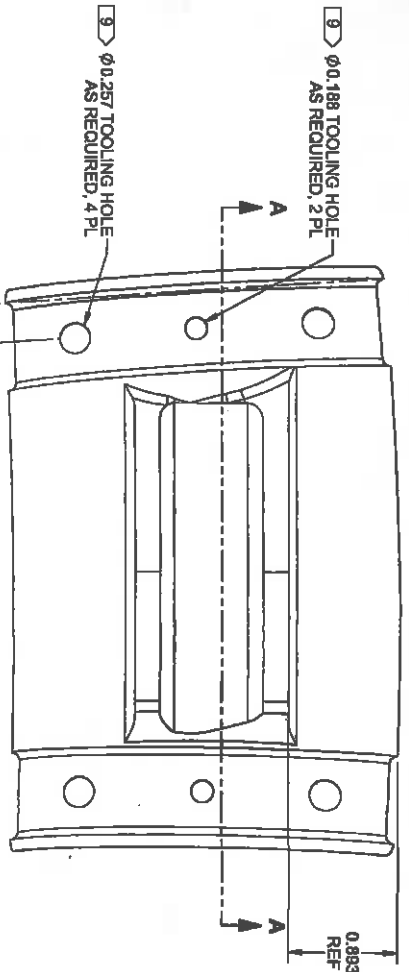
- NOTES:**
- 1) MATERIAL: NA
 - 2) FINISH: PRIME AND PAINT WHITE PER DART OSI 005 4.2
 - 3) TOLERANCES: PER DART OSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: NONE
 - 7) WEIGHT: 0.42 lbs
 - 8) NA57708-021 BUSHINGS ARE PRESS FIT INTO D5134-1 DAMPER SUPPORT, IN ORIENTATION SHOWN

APPROVED

DESIGN	AP	AP	15.04.24
CHECKED	CP	AP	14.09.02
MFG. APPR.	JLM	BY	DATE
APPROVED	HS	TITLE	REV. B
DATE	15.04.24	DAMPER SUPPORT ASSY	SHEET 1 OF 4
SCALE			
NTS			

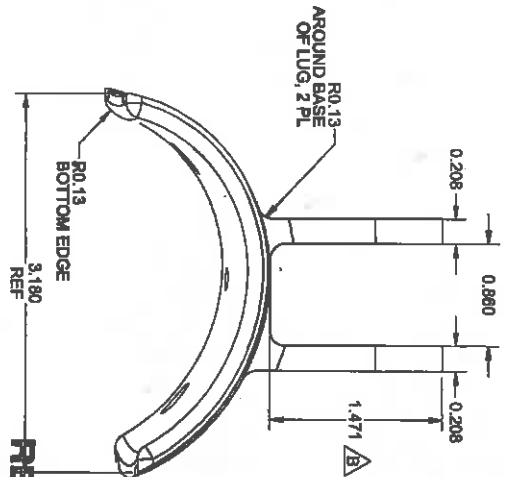
RELEASED
2015 MAY 12
A.R. Evans-cro

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 161624 MWS
170830



D5134-1 DAMPER SUPPORT, LH

- NOTES:
- 1) MATERIAL: ALUMINUM 7075-T73 (T7351 / T73510 / T73511) BAR PER AMS-QQ-A-200/1 OR AMS-QQ-A-225/9 (AMS 4124) OR AMS-QQ-A-250/12 (AMS 4078) REF DART SPEC M7075173B
 - 2) FINISH: CHEMICAL CONVERSION COAT PER OSI 005 4.1
 - 3) TOLERANCES: PER DART OSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: N/A
 - 6) IDENTIFICATION: IDENTIFY WITH DART LOGO AND P/N "D5134-041" IN AREA SHOWN USING 0.125 HIGH X 0.010-0.020 DEEP LETTERING PER DART OSI 044 6.3, IDENTIFY WITH DART B/N PER DART OSI 044 6.1
 - 7) WEIGHT: 0.38 lbs
 - 8) ALL NON-DIMENSIONED FEATURES DEFINED PER DRAWING FILE "D5134-1-REV.B.SLDPRT"
 - 9) POSITION TOOLING HOLES AS REQUIRED WHILE MAINTAINING MINIMUM 2D EDGE DISTANCE AND 4D PITCH BETWEEN HOLES



APPROVED

DESIGN	AP	AP	DART AEROSPACE LTD
DRAWN	AP	CP	HAWKSBURY, ONTARIO, CANADA
CHECKED	CP	JLM	D5134
MFG. APPR.	JLM	HS	DAMPER SUPPORT ASSY
APPROVED	DS	NTS	SCALE
DATE	15.04.24		

RELEASED

2015 MAY 12
A.S. ECMS-570



Work Order ID 166335

Friday, September 15, 2017 11:20:17 AM

166335

SHIP Sept 22

Item ID: D4593-1

Revision ID:

Item Name: Base

Start Date: 9/15/2017

Required Date: 9/22/2017

Reference:

Accept

N900040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Approvals:

Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run

Start

NR1

Stop

NR2

Sequence ID / Work Center ID

Operation Description

Draw Nbr

Revision Nbr

Set Up / Run Hours

Tool ID Tool # Plan Code

Accept Qty

Reject Qty

Reject Number

Insp. Stamp

D4593

A

100

1111

Bandsaw

BAND SAW

Memo

Jesapa Bandsaw

Cut blank: 1.00" x 2.500" x 4.120" long

0.00

0.00

2x 0

2017/09/16

110

1111

HAAS 1

HAAS CNC VERTICAL MACHINING #1

Memo

HAAS CNC vertical machine #1

Machine D4493-1 as per Folio FB092 and Dwg

2.16

0.37

2x 0

2017/09/16

Dwg Rev: A
FOLIO REV: A

120

1111

QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

2x 0

2017/09/16

MD 18 Jun 2019



DQA: _____ Date: _____
QA Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

Work Order update only

Work Order: <u>16335</u>		AGAINST DEPARTMENT/PROCESS	
Part No. <u>D4593-1</u>		Cross tube ☐ Water Jet ☐	
NCR No. <u>19-7158</u>		Small Fab ☐ Prod. Eng. Coord. ☐	
Date: <u>17-09-19</u>		Finishing ☐ Rec/Store/Packaging ☐	
Step #: <u>110</u>		Composite ☐ Supplier ☐	
Disposition		Engineering ☐	
Description Work Order Deviation		Quality ☐	
TAPERED 8-32 HOLE DRILLED ON WREANG		Other ☐	
FACE. QTY(2).		MRB (QS1042) Approval	
OK TO FILL HOLES W/ WELD + GRIND		DAS <u>22</u> <u>17-09-19</u>	
ALU ROD: M137078		Completed By DAS <u>24</u>	
GRIND DRILL/TAP HOLES		SEP 18 2017 9-89	
ON CORRECT FACE PER DWG.		Lead hand / Supervisor	
DAS <u>49</u> <u>17/07/19</u>		Approval Verification	
DAS <u>17-09-19</u>		QC / QA Coordinator	
		Approval	
		PD <u>17-09-21</u>	
FAULT CATEGORY			
Root Cause		Positioned Wrong	
Environment ☐		Outside Dimensions	
Design ☐		Over/Under tolerance	
Doc/Data ☐		Part Incorrect	
Equip/Tooling ☐		Part Lost/Missing	
Handling/Pre ☐		Part Moved	
Material ☐		Drawing	
Internal Transport ☐		Finish	
Tribal Knowledge ☐		Misread	
LOA ☐		Turning Sequence	
Substation ☐			
Past Expiry Date ☐			
Misidentified ☐			
No Re-verification ☐			
Operator ☒			
Offset/Setup ☐			
Supplier ☐			
Training ☐			
Use for Testing ☐			
Poor Information ☐			
Rushing ☐			
Product Improvement ☐			
Process Improvement ☐			
Manufacturing Process ☐			
Past Due ☐			
Pressure/Forced ☐			
Bending ☐			
Centre Not Concentric ☐			
Cracks ☐			
Crimp/Kink/Ripple/Wave ☐			
Cuffs ☐			
Crushing ☐			
Heat Treat ☐			
Wave/Twist in Tube ☐			
Marks/Chatter ☐			
Temperature/Cure ☐			
Set-up ☐			
BOM/Route ☐			
Broken/Damage/Defect ☐			
Inspection Incomplete/Unqualified ☐			
Contamination ☐			
Countersink ☐			
Cut Too Short ☐			
Instructions Incomplete/Unclear ☐			
Drill Holes ☐			
Power Loss/Surge ☐			
Folio/Program ☐			
Grain ☐			
Weld ☐			
Wrong Stock Pulled ☐			
Out of Sequence ☐			
Off-set ☐			
Mislabeled ☐			
Fit/Function ☐			
Misaligned/off center ☐			
OTHER: ☐			